

25

Date: Friday, 5/25/2007 12:45:40 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206L FWD X-TUBE
 Job Number : 32663
 Estimate Number : 10553
 P.O. Number : *N/A* Part Number : D206667103
 This Issue : 5/25/2007 S.O. No. : *N/A* Drawing Number : D206-667-143 REV B
 Prsht Rev. : NC Project Number : *N/A*
 First Issue : *N/A* Type : LANDING GEAR Drawing Revision : B
 Previous Run : 32456 Material : *N/A*
 Due Date : 6/20/2007 Qty: 1 Um: Each
 Written By : *[Signature]*
 Checked & Approved By : *[Signature]*
 Comment : Est Rev: F 05.09.01 Add holes for compatibility with Bell
 Skid tubes KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-103 CHG002

PER ATTACHED

2.0 D6002115 Crosstube material



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6002-115 Crosstube *B29113*

Check OD = 2.250"; ID = 1.750"

S.F 07/06/21

3.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA087

2-Turn first side as per Folio FA087

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143.

S.F 07/06/21

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

S.F 07/06/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 12:45:40 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 32663

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA087

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143.

3-Remove sand and plugs

4-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-143

Inside of Cuff(Donot engrave on outside of tube)

JS 07/06/22

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

JS 07/06/22

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 07.06.22

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Polish entire outside surface of crosstube

JD 7-7-3

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 07-07-03

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JD 7-7-3

11.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D206-667-143 using CNC bender program 206L-fw and Folio FT017

EL 7-7-4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 12:45:41 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 32663

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC15

DIMENSIONAL CHECK OF X-TUBES



07-07-04



Comment: DIMENSIONAL CHECK OF X-TUBES

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill all (3) top holes.

2-Drill and Ream all holes in tube to finish size using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Check dimensions between holes on all four sides.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill only the top (2) holes.

5-Drill & ream the top (2) holes to finish size using drill Jig DT8541 & DT8542 as per Dwg D206-667-143

6-Drill Fwd rivet holes using drill Jig DT8787FWD as per Dwg D206-667-143. Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8787AFT as per Dwg D206-667-143.

8-C'sink holes as per Dwg D206-667-143. Allow rivet to sit below surface to compensate for paint.

9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143

070705
JB 7-7-5

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JB 7-7-5

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



07-07-06



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

16.0

QC5

INSPECT WORK TO CURRENT STEP



07-07-06



Comment: INSPECT WORK TO CURRENT STEP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 12:45:41 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 32663

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description:

17.0

OUTSIDE SERV.10

OUTSIDE SERVICES -LG



Comment: Sub-Contracting OUTSIDE SERVICES
Liquid Penetrant Inspection as per QSI 0380r
Issue P/O: 4113 LPI as per ASTM 1417
Level 2 Attach copy of NDT results to work order

CD 07/07/06 @

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Inspect for transit damage
Ensure copy of NDT results attached to work order.

EP 07/07/09 @

19.0

QC6

DIMENSIONAL CHECK



Comment: Inspect for damage & ensure results are as per Dwg D206-667-103

DATA-10 @

20.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

7 ml 07 07 12

21.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint
Wrap in plastic bag to protect from scratches

DATA-13 @

22.0

D2856400

Abrasion Strip



Comment: Qty.: 1.2138 f(s)/Unit Total : 1.2138 f(s)
Pick:

Qty Part number Description Batch
2 D2856-400(Cut to 6.94") Abrasion Strip

32020 ml 07 07 13

23.0

D2873043

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty Part number Description Batch
2 D2873-043 Nut Plate

29286 85 07 07 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 12:45:41 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 32663

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

D2873045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-045

Nut Plate

30450

RT

07-07-10

25.0

D28911

Support 2.25 dia



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2891-1

Support

28388

ml 07 07 13

26.0

MS20601AD4W8

RIVET



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W8 Rivet

102850

RT 07-07-10

27.0

MS2192020

Clamp (per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-20

Clamp

102712 x2

ml 10/10/02 x2

ml 07 07 13

28.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8579. .Note: (2) Aft holes should be facing up.

2-Install supports and clamps as per Dwg D4206-667-143. Torque clamps to 80-100 in lb

3-Install nut plates as per Dwg D206-667-143. Touch-up rivet heads with Imron paint.

ml 07 07 13 (1)

RT 07-07-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 12:45:41 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 32663

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/07/16 (41)

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

31.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M103481 ✓

32.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M103830 ✓

33.0

AN57A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:Packing Kit

Qty Part number

10 AN5-7A

Description Batch

Bolt

M103389 ✓

34.0

AN530A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:Packing Kit

Qty Part number

4 AN5-30A

Description Batch

Bolt

M103389 ✓

35.0

AN960JD516

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:Packing Kit

Qty Part number

18 AN960JD516

Description Batch

Washer

M104156 ✓

2/10/16 59

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: DD Date: 07/12/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 12:45:41 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 32663

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

37.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-103

Location: _____

PPP Rev: _____

PPP 33 SW

07/16/07

38.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07-07-21

Job Completion



07-07-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

104.98

DART AEROSPACE LTD	Work Order:	32663
Description: Crosstube Assembly (206L High Fwd)	Part Number:	D206-667-143
Inspection Dwg: D206-667-143 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

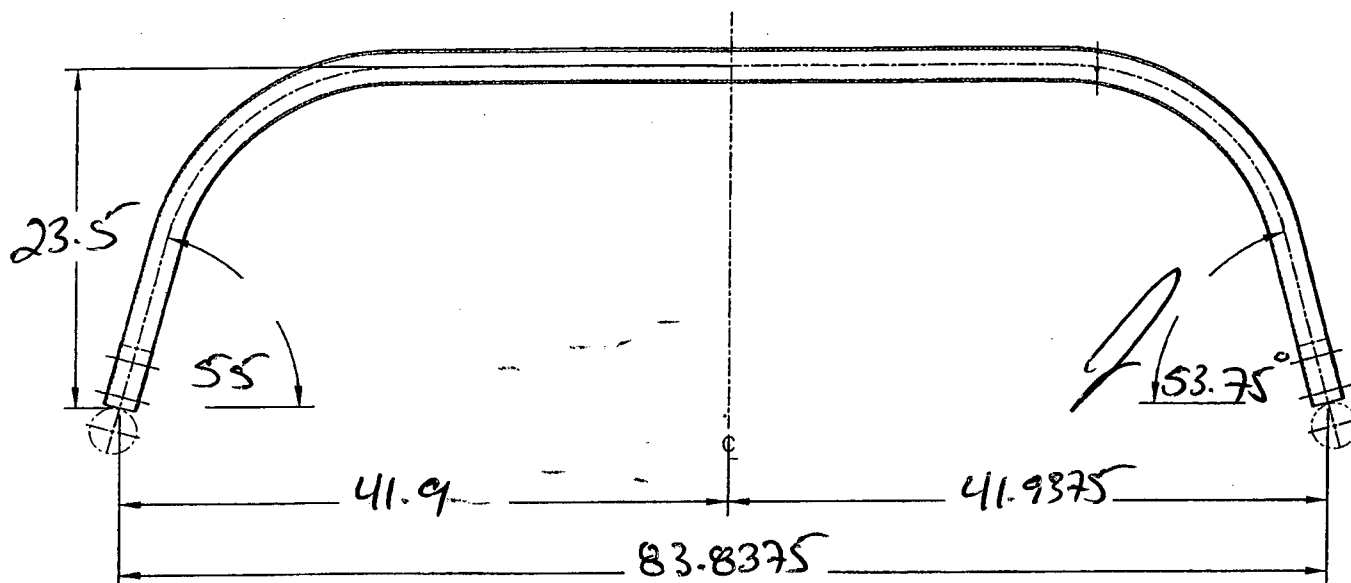
Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.243			
	1.982	+0.005/-0.000	1.985			
	2.019	+0.005/-0.000	2.021			
	2.058	+0.005/-0.000	2.061			
	2.097	+0.005/-0.000	2.100			
	2.136	+0.005/-0.000	2.139			
	2.176	+0.005/-0.000	2.179			
	2.201	+0.005/-0.000	2.204			
	0.125	+/-0.010	.125			
	0.400 x 30°	+/-0.010	.400			
	R0.063	+/-0.010	.063			
	R0.500	+/-0.010	.500			
	4.438	+/-0.030	4.448			
SIDE B	104.98	+/-0.020	104.98			
	2.240	+0.005/-0.000	2.243			
	1.982	+0.005/-0.000	1.985			
	2.019	+0.005/-0.000	2.021			
	2.058	+0.005/-0.000	2.061			
	2.097	+0.005/-0.000	2.100			
	2.136	+0.005/-0.000	2.139			
	2.176	+0.005/-0.000	2.179			
	2.201	+0.005/-0.000	2.204			
	0.125	+/-0.010	.125			
	0.400 x 30°	+/-0.010	.400			
	R0.063	+/-0.010	.063			
	R0.500	+/-0.010	.500			
	4.438	+/-0.030	4.448			

Measured by: <i>SA</i>	Audited by: <i>SA</i>	Prototype Approval:	N/A
Date: 07/06/22	Date: 07.06.22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.05.06	New Issue (P/O D206-667-103)	KJ/RF	
B	06.03.09	Dwg Rev updated	KJ/JLM <i>SA</i>	<i>SA</i>

DART AEROSPACE LTD		Work Order:	32663
Description: Crosstube High Fwd (206L)		Part Number:	D206-667-103
Inspection Dwg: D206-667-143 Rev: B		Page 1 of 1	

Required Dimension	Min	Max
Height	23.46	23.58
1/2 Span	41.86	41.98
Angle	54	56
Total Span	83.72	83.96



Comments

QC15 Inspection	
Date	07-02-04

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED HDS	APPROVED HDS	DRAWING NO. D206-667-143	REV. B SHEET 1 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206L HIGH FWD) NTS	
A	00.11.17	NEW ISSUE	
B	05.07.26	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED
05-07-26 H

UNDER REVIEW

05.08.10 PH

re-draw detail F
PH

07.05.02

Qty	Part Number	Description
X	D206-667-143	CROSSTUBE ASSEMBLY (206L HIGH FWD)
1	D6002-115	CROSSTUBE
2	D2873-043	NUT PLATE
2	D2873-045	NUT PLATE
2	D2856-400-694	ABRASION STRIP
2	D2891-1	SUPPORT
14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
4	MS21920-20	CLAMP

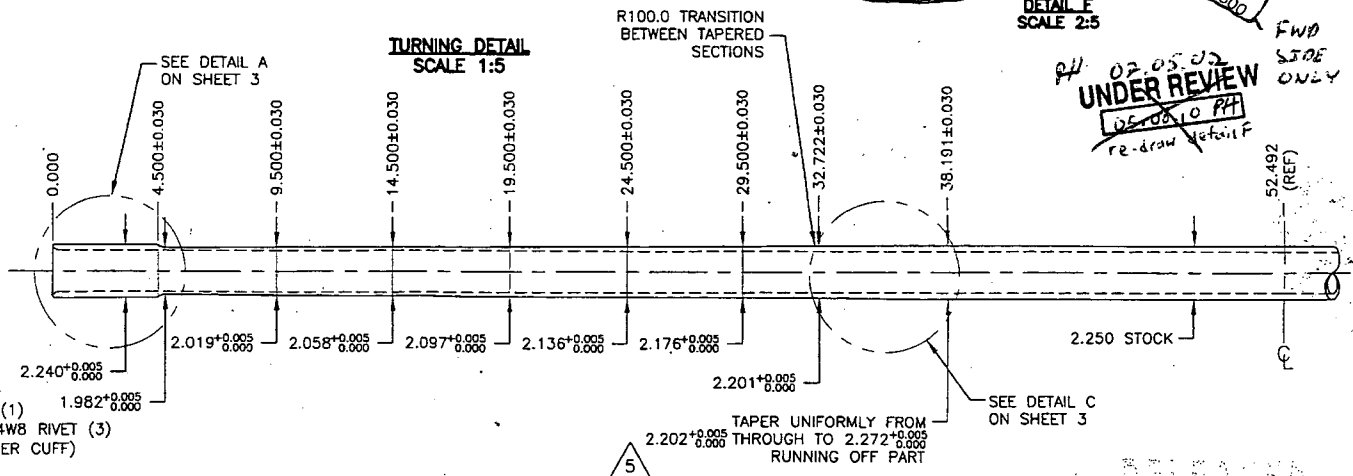
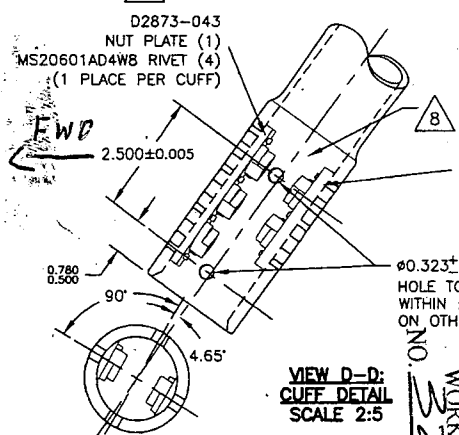
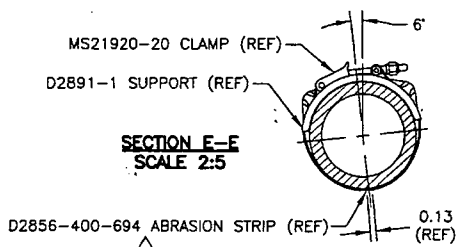
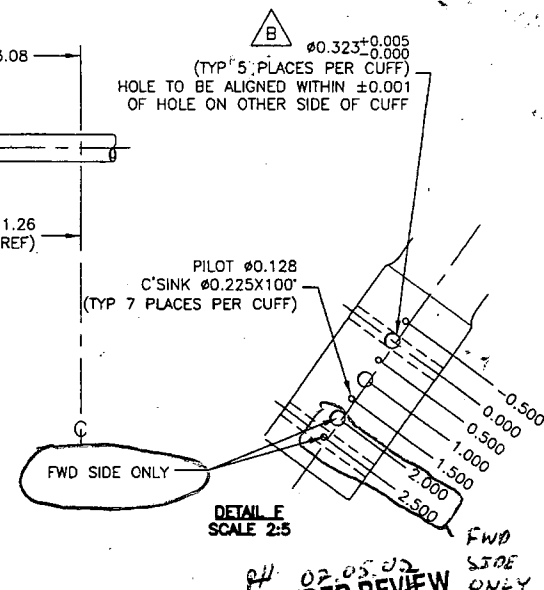
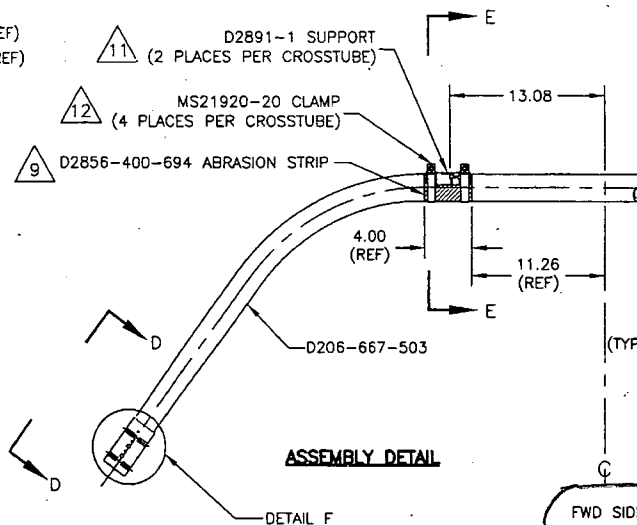
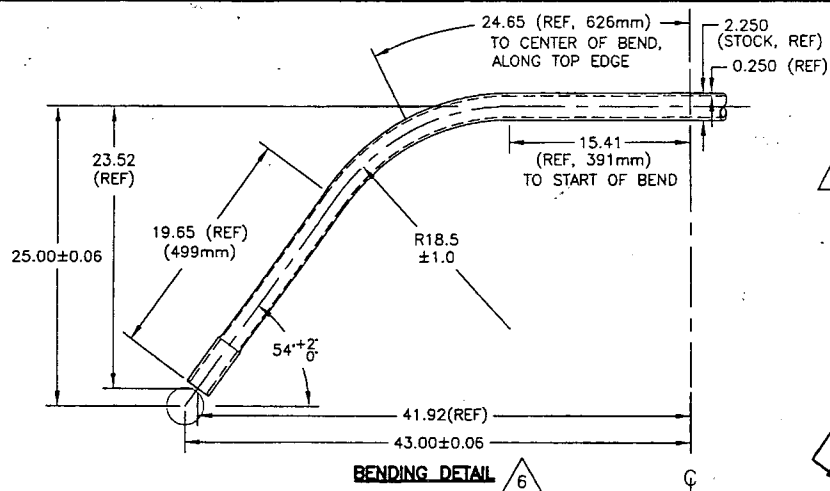
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6002-115
FINISHED LENGTH = 104.98±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-694 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2891-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32663

Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

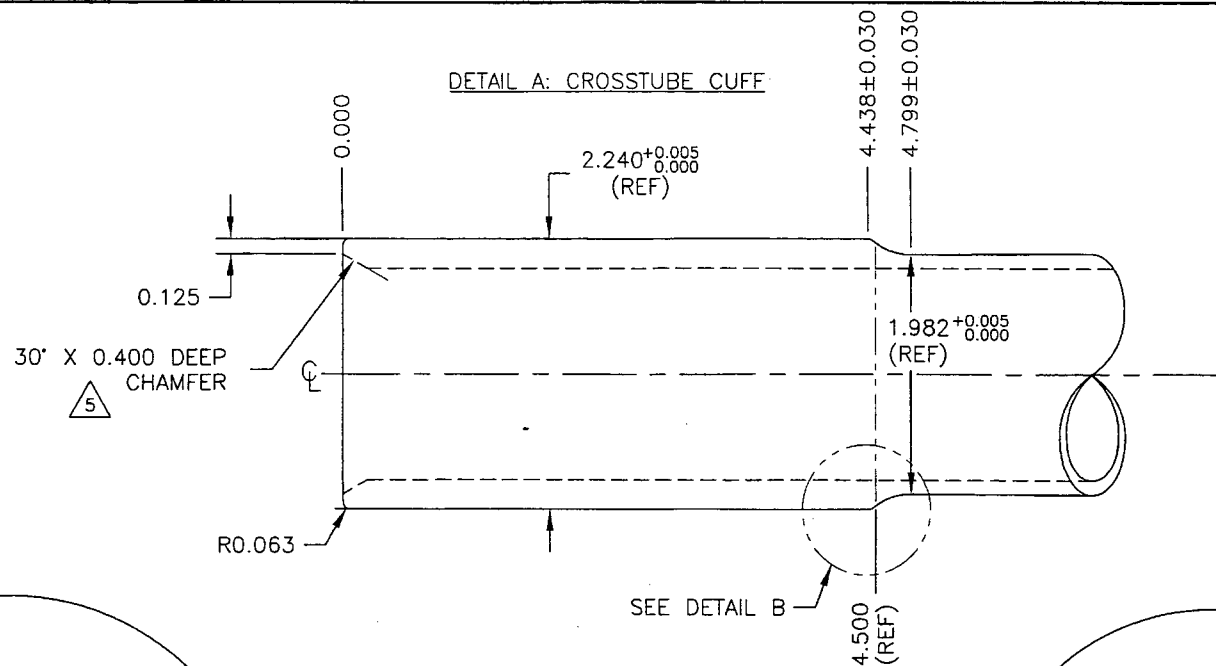


COPYRIGHT © 2000 BY DART AEROSPACE LTD.		DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		PH	PH		
CHECKED		PH	PH	DRAWING NO.	REV. B
DATE		05.07.26	05.07.26	D206-667-143	SHEET 2 OF 3
				TITLE	SCALE
				CROSSTUBE ASS'Y (206L HIGH FWD)	1:10

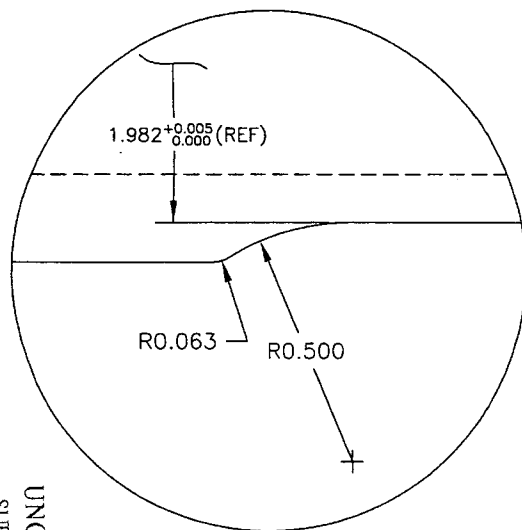
SHOP COPY
 RETURN TO
 ENGINEERING
 CONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER NO. 22663

05-07-26

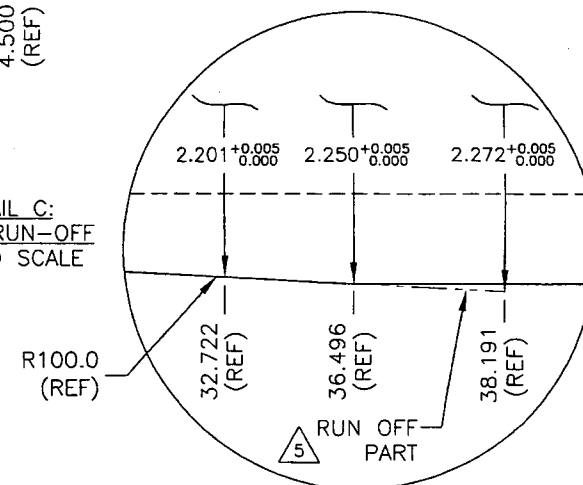
05.07.26



UNDER REVIEW
 06.08.10 PH
 07.05.02



DETAIL C:
 TAPER RUN-OFF
 NOT TO SCALE



NO. 32863
 WORK ORDER
 WITHOUT NOTICE
 SUBJECT TO AMENDMENT
 UNCONTROLLED COPY
 ENGINEERING
 RETURN TO
 SHOP COPY

COPYRIGHT © 2000 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA
	PH	PH		
	CHECKED	APPROVED	DRAWING NO.	REV. B
	<i>HDS</i>	<i>HDS</i>	D206-667-143	SHEET 3 OF 3
	DATE		TITLE	SCALE
05.07.26		CROSSTUBE ASS'Y (206L HIGH FWD)	1:1	



HeathAir

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 36827

A.M.O. Number: 46/90

NON-DESTRUCTIVE TESTING REPORT

AIRCRAFT / COMPONENT INFORMATION

REGISTRATION: -

MODEL/TYPE: -

SERIAL NUMBER: -

TOTAL HR/LDG: -

OPERATED BY: -

BASED AT: -

INSPECTION REQUIREMENTS

Carry out FPI of (5) cross tubes (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty (2) P/N D206-667-103 Cross tube S/N B32663 & B32664.
Qty (3) P/N D206-667-203 Cross tubes S/N's B32668, B32669 & B32670.

☐ RADIOGRAPHY

☐ ULTRASONIC

☒ PENETRANT

☐ MAGNETIC PARTICLE

☐ EDDY CURRENT

INSPECTION REPORT

Fluorescent penetrant inspection was performed in accordance with the above requirements on (5) Cross Tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)
Ardrox 970P25E Batch #04B503.

(5) cross tubes inspected. (5) PASSED inspection / (0) FAILED inspection.

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH
THE APPLICABLE STANDARDS OF AIRWORTHINESS

INSPECTED BY: *[Signature]*
B. VURPILOT

DATE July 6, 2007

INSPECTION
STAMP(S) *n/r*

CUSTOMER INFORMATION

CUSTOMER: Dart Aerospace

ADDRESS:

P.O. NUMBER

4113

CONTACT NAME:

Linda

LABOUR

@

\$

MATERIALS

@

TRAVEL EXPENSES

@

GST

HOTEL EXPENSES

@

PST

INVOICE NO.

TOTAL \$

WHITE COPY - INSPECTION FILE • YELLOW COPY - CUSTOMER • PINK COPY - ACCOUNTANT

Days: Friday, 5/25/2007 12:45:40 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206L FWD X-TUBE
Job Number	: 32663		
Estimate Number	: 10553		
P.O. Number	:	Part Number	: D206667103
This Issue	: 5/25/2007 S.O. No. :	Drawing Number	: D206-667-143 REVB
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LANDING GEAR	Drawing Revision	: B
Previous Run	: 32456	Material	:
Written By	:	Due Date	: 6/20/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>07.05.28</u>		
Comment	: Est Rev:F 05.09.01 Add holes for compatibility with Bell Skidtubes KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-103 CHG002

07.06.04

2.0

D6002115

Crosstube material



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6002-115 Crosstube

Check OD = 2.250"; ID = 1.750"

3.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA087

2-Turn first side as per Folio FA087

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143.

4.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

REFERENCE ONLY